

**Work Order ID 68258**

Monday, April 11, 2011 10:33:18 AM



Page 1

Item ID: D3417-9

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: *M*Date: *4/11/11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3417	F

100



Hardinge CNC LATHE SMALL

0.00

*nl 11. 4. 15**30*

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev: *M*Dwg D3417 Rev: *F*

2-Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*nl 11. 4. 15**30*

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68258**

Monday, April 11, 2011 10:33:18 AM



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Item ID: D3417-9

Accept



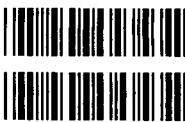
Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

4/11/15

30 0

130



Packaging

Packaging

Identify as per dwg & Stock Location: 53

0.00

11/4/19 SL 30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/19 JJ

4/11/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

# Picklist Print

Monday, April 11, 2011 10:33:25 AM

Page 1

Work Order ID: 68258



Parent Item: D3417-9



Parent Item Name: Washer

Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 		Purchased	No			f		22.7500		0.93473		 JL 11-4-08	

DELRIN ROUND BAR 1.25"

Location	Loc Qty	Loc Code
MAT055	22.75	
114586	22.75	1.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68258
Description: Washer	Part Number:	D3417-9
Inspection Dwg: D3417 Rev: F		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>JK</i>	Audited by:	<i>JK</i>	Preliminary Approval:	
Date:	11-4-15	Date:	11/04/15	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	10.11.08	New Issue	KJ	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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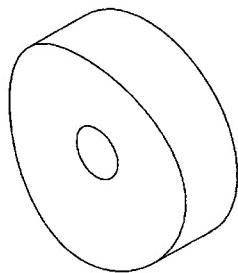
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

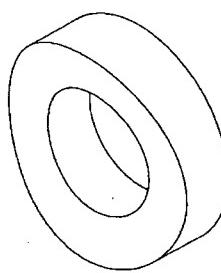
SHOP COPY  
RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 68258

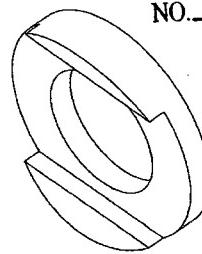
*PL11-04-11*



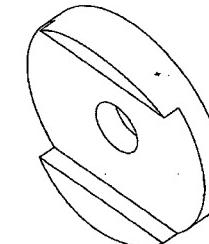
D3417-1 WASHER



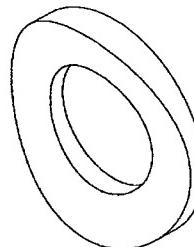
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

- NOTES:  
 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
     REF DART SPEC M-DELRIN-R  
     OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
     REF DART SPEC M-DELRIN-B  
     OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
     REF DART SPEC M-DELRIN-S  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: D3417-1, 0.020 lbs  
     D3417-3, 0.010 lbs  
     D3417-5, 0.010 lbs  
     D3417-7, 0.010 lbs  
     D3417-9, 0.004 lbs

**RELEASED**  
2010-09-15

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2), REFORMAT TO "B" SIZE & ADJUST TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED UNDER THE DART AEROSPACE LTD CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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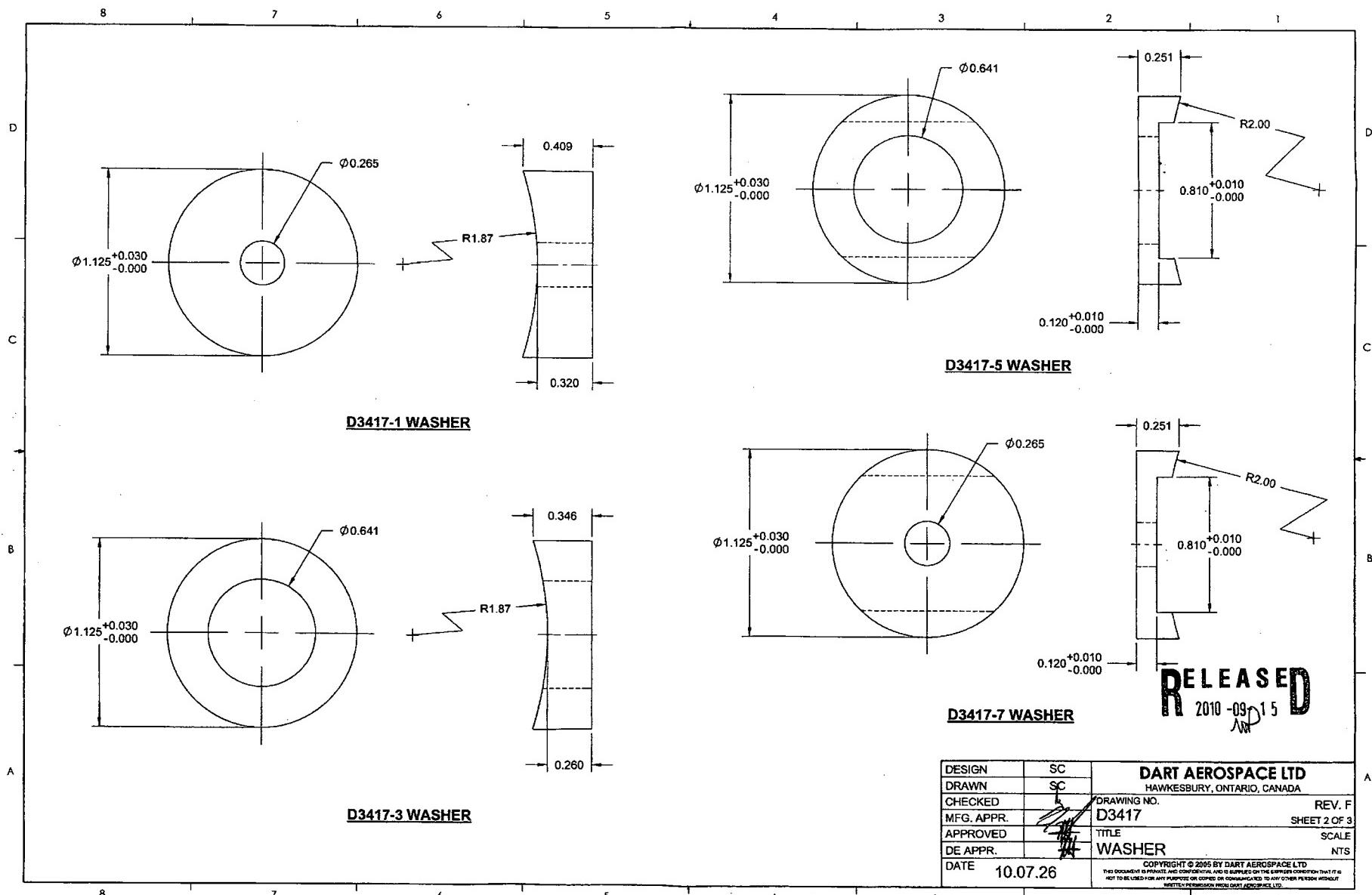
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W0 98258



DESIGN	SC	DART AEROSPACE LTD
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3417 REV. F
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE WASHER
DE APPR.		SCALE NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THE ORIGINAL PURCHASED BY THE ORIGINAL OWNER OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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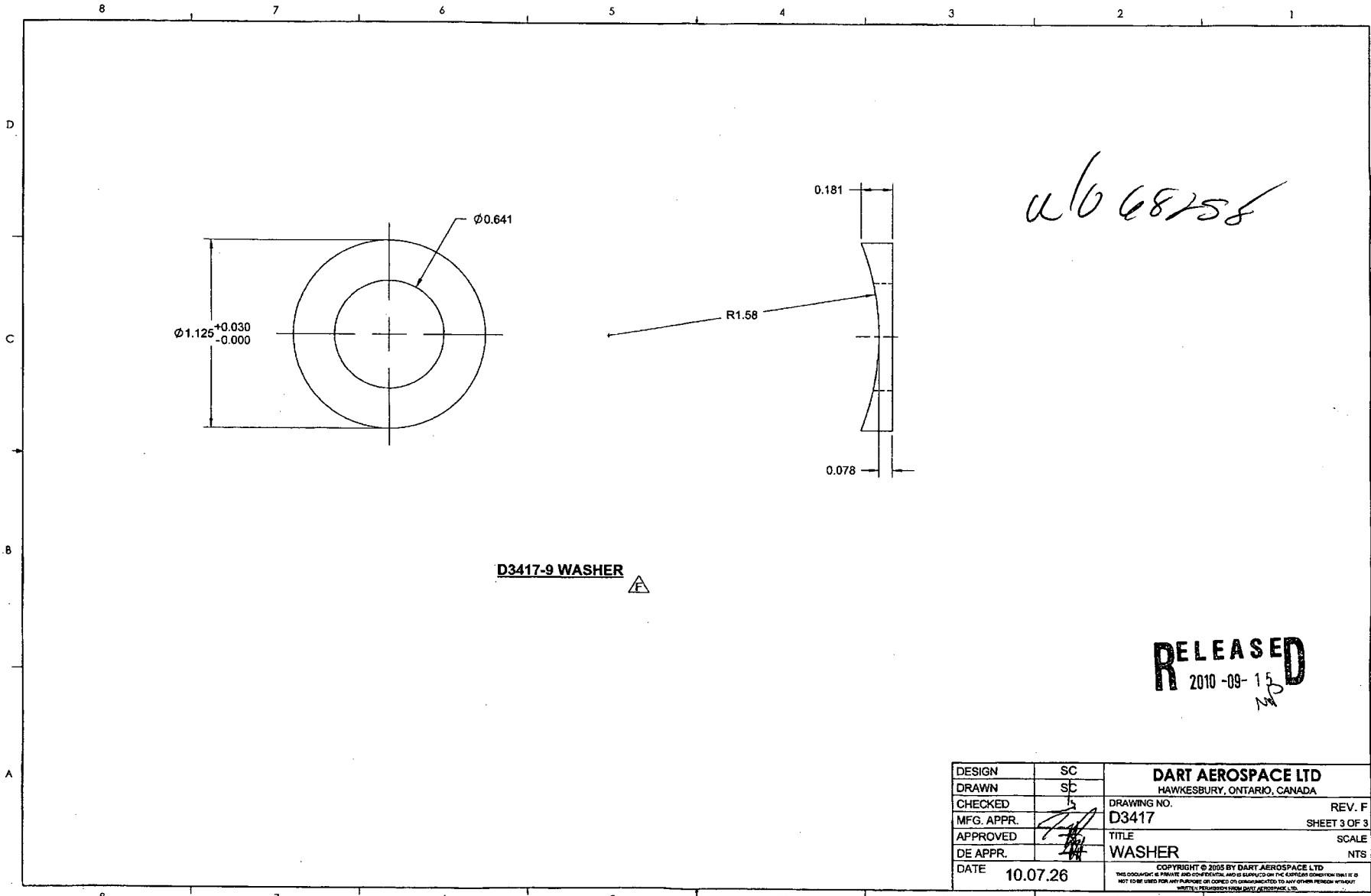
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